

Work Order ID 64624 -2

Thursday, December 09, 2010 12:41:51 PM



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Item ID: D350-588-011

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010 Start Qty: 10.00

Required Date: 12/10/2010 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: *mf*

Date: *12-09*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

Salaloz

OK for CL 10/12/13

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/12/13

120

0.00



QC- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Salaloz

(X)

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Item ID: D350-588-011

Accept

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010 Start Qty: 10.00

Required Date: 12/10/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Setup Start

Stop

Run Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Packaging

Memo

Identify and pack for shipping as per PPP D350-588-011

Location: 20C

PPP Rev:

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11/01/07 (R)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/01/07
JMF
11-01-07

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Work Order ID: 64624

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification



Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: M 04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

132.0000

2

20



Screw

Location

Loc Qty

Loc Code

ST328

132

113064

1

113749

1

114056

30

116304

100

120

Each

76.0000

8

80

AN526C832R8

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST327

76

114718

76

120

Each

17.0000

8

80

AN526C832R9

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST327

17

115936

17

M114086

M116410 13 x 6

114718 63x

116400 11 x 64mm

M115936 13x

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Work Order ID: 64624

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

AN960JD10 NAS1149D0363J Purchased



Washer

No

120

Each

8.0000

Start Date: 12/10/2010

Start Qty: 10.00

Required Date: 12/10/2010

Required Qty: 10.00



M118622

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD8 NAS1149DN832J Purchased



Washer

No

120

Each

10.0000



M116391

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2143 Manufactured

No

120

Each

22.0000



10

Location

Loc Qty

Loc Code

ST198

22

55323

3

63595

19

D2144 Manufactured

No

120

Each

28.0000



5532314
6359514
12/12/14(10)

Location

Loc Qty

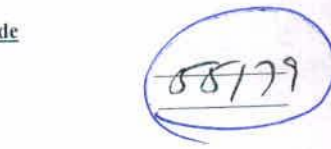
Loc Code

ST198

28

55179

28



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Parent Item: D350-588-011



Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2150



Packer Doubler, Hinge

Manufactured No

120 Each

18.0000



64309 GP

LocationLoc QtyLoc Code

ST007

18

55178

6

63562

12

120 Each

29.0000

55178 2P
63562 12

D2151



Packer Doubler, Hinge

Manufactured No

LocationLoc QtyLoc Code

ST007

29

62246

29

120 Each

7.0000



62246

64311 SP

D2153



Door Prop

Manufactured No

LocationLoc QtyLoc Code

ST272

7

59818

7

120 Each

66.0000



59818 SP

64311 SP

D2154



Stud Bracket

Manufactured No

LocationLoc QtyLoc Code

ST007

66

55325

1

63597

15

64312

50

63597

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Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2237

Manufactured No

120 Each

28.0000

2 20



Striker Plate

Location

Loc Qty

Loc Code

ST010

28

62212

28

120 f

506.5000

7.25

62212
7631579

D2461

Manufactured No



Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

506.5000105

39782

6.5

55054

0.00001053

63880

500

120 f

202.3205

7.25

63880
7631579

cut 1 X 87.00"

D2463



Seal

Location

Loc Qty

Loc Code

ST404

202.32053

55561

1.68

62597

200.64053

cut 1 X 87.00"

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2583

 Latch Bracket

Manufactured No

120 Each

55.0000

2 20



Location

Loc Qty

Loc Code

ST017 53

64080 22

64313 31

ST018 2

56527 2

64080 18x
 64313 2x

D2585

 Mounting Channel

Manufactured No

120 Each

30.0000

2 20



Location

Loc Qty

Loc Code

ST018 30

62676 30

62676

D2586

 Door Latch

Manufactured No

120 Each

25.0000

2 20



B64656 11/1/08

Location

Loc Qty

Loc Code

ST204 25

61655 25

61655 18x

D2587

 Door Slug, 350 Hinge

Manufactured No

120 Each

3.0000

1 10



64314 9x
 56555 1x
 12/12/14

Location

Loc Qty

Loc Code

ST019 3

56555 3

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: ~~10.00~~ 10

Required Qty: 10.00

D2589

Manufactured No

120 Each

145.0000

1 10



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST019

145

58194

145

120 Each

8.0000

58194

10

D2690-17

Manufactured No



Cable

Location

Loc Qty

Loc Code

ST021

8

62480

8

120 Each

16.0000

62480

10

D2857-1

Manufactured No



Hinge Bracket

Location

Loc Qty

Loc Code

ST026

16

57924

16

120 Each

25.0000

57924

10

D2857-2

Manufactured No



Hinge Bracket

Location

Loc Qty

Loc Code

ST027

25

55020

1

57925

24

57925

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2858-1

Manufactured No

120

Each

7.0000

1 10
63698



Hinge Bracket

Location

Loc Qty

Loc Code

ST027

7

56423

1

61522

6

120

Each

0.0000

1 10
62020

D2858-2

Manufactured No



Hinge Bracket

FG-778150-550-ROL

Purchased No

120

sf

1,823.150

1 10
m113905



7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

ST404

1823.15

108932

18

111166

397

113905

1408.15

120

Each

5,864.000

12 120
m104377

1- cut 1 square ft of glass cloth

MS20426AD3-4

Purchased No



RIVET

Location

Loc Qty

Loc Code

ST316

5864

104374

1864

110398

4000

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

MS20470AD4-5 Purchased

No

120 Each

94.0000

18 180



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST309

94

114761

94

120 Each

370.0000

18 180

MS21042L08

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

370

116082

22

116188

348

120 Each

1,211.000

4 40

MS21042L3

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

1211

114784

215

115835

996

120 Each

119.0000

2 20

MS27039-08-11

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST288

19

114382

19

ST290

100

116289

100

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification



Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

MS27039-1-15

Purchased

No

120

Each

125.0000

2

20



10/12/13 (10)

Screw

Location

Loc Qty

Loc Code

ST292

125

114718

25

116169

100

M114718 17x
M116169 3x

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011 Aft Door Fwd Hinge Modification Kit	1.0 lb 0.45 Kg	-21.0 in -0.53 m	-21.0 in-lb -0.24 m-Kg	+170.0 in +4.32 m	+170.0 in-lb +1.96 m-Kg
D350-588-041* Aft Door Assembly	2.0 lb 0.91 Kg	-21.0 in -0.53 m	-42.0 in-lb -0.48 m-Kg	+170.0 in +4.32 m	+340.0 in-lb +3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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